

Date: Thursday, 01/05/2008 9:45:54 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)		
Job Number	: 38921			Part Number	: D2572	
Estimate Number	: 10531			Drawing Number	: D2572 REV E	
P.O. Number	:			Project Number	: N/A	
This Issue	: 01/05/2008		S.O. No. :	Drawing Revision	: E	
Prsht Rev.	: NC			Material	:	
First Issue	: / /		Type :	MACHINED PARTS	Due Date	: 10/05/2008
Previous Run	: 38654				Qty:	8
Written By	:			Um:	Each	
Checked & Approved By	: <u>JUL 08.5.01</u>					
Comment	: Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101005	Saddle Billet	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2572 Ensure that grain is along 5.00" length Batch No: <u>B34374</u>	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No: <u>88</u> Double check by: _____ 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 01/05/2008 9:45:54 AM
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Customer: CU-DAR001 Dart Helicopters Services

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Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

8/08/08/08

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

JL 08/05/14

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



(8)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

W/B 08-05-20

7.0 POWDER COATING

POWDER COATING



(8X)

M107925

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

11:15am

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

320°F
11:45am

M/L 08/05/20

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(6)

Comment: INSPECT POWDER COAT

Ex 08/05/20

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Sty 32

FINAL INSPECTION/W/O RELEASE

Ident 08/05/20 (8)

10.0 QC21



08/05/2020

Comment: FINAL INSPECTION/W/O RELEASE

MF 08-05-22

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	38921
Description: Saddle, Fwd Inboard				Part Number:	D2572
Inspection Dwg: D2572 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.443	0.443	443	.441		
B	1.745	1.755		1.749	1.750	1.750	1.750		
C	3.495	3.505		3.499	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.749	1.750	1.7500		
E	7.990	8.010		8.001	8.001	8.001	8.001		
F	0.490	0.510		0.506	0.495	.500	.499		
G	0.257	0.262		0.259	0.259	0.259	0.259		
H	0.375	0.380		0.378	0.378	0.378	0.378		
I	0.490	0.510		0.507	0.508	0.502	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.177		
K	0.558	0.578		0.5705	0.5705	0.570	0.5715		
L	1.174	1.184		1.179	1.179	1.180	1.180		
M	1.490	1.500		1.495	1.495	1.493	1.493		
N	2.495	2.505		2.500	2.500	2.500	2.499		
O	3.869	3.879		3.874	3.874	3.874	3.876		
P	0.115	0.135		0.123	0.123	0.124	0.124		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.248	0.248	0.250	0.250		
S	0.115	0.135		0.122	0.122	0.122	0.1235		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.958		
V	0.230	0.250		0.230	0.230	0.237	0.232		
W	0.115	0.135		0.126	0.121	.124	.124		
X	0.307	0.312		.309	.309	.309	.309		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		0.364	0.361	.362	.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.624	0.626	.626	.625		
AC	0.053	0.073		0.0625	0.0625	.063	.063		
AD	0.240	0.260		0.243	0.243	0.242	0.243		
AE	1.375	1.395		1.3885	1.3885	1.3915	1.391		
AF	0.115	0.135		0.130	.130	.130	.130		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.243	0.244	0.245	.250		
AI	2.000	2.020		2.001	2.003	2.009	2.0085		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: DJP
Date: 08/05/10

Audited by: JL
Date: 08/05/10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<u>JL</u> <u>JLM</u>

DART AEROSPACE LTD				Work Order:	38921
Description: Saddle, Fwd Inboard				Part Number:	D2572
Inspection Dwg: D2572 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

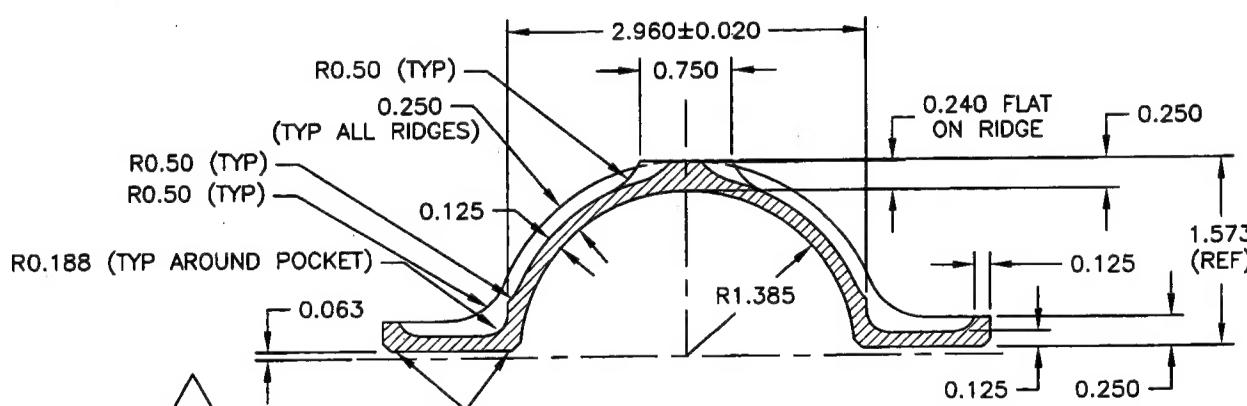
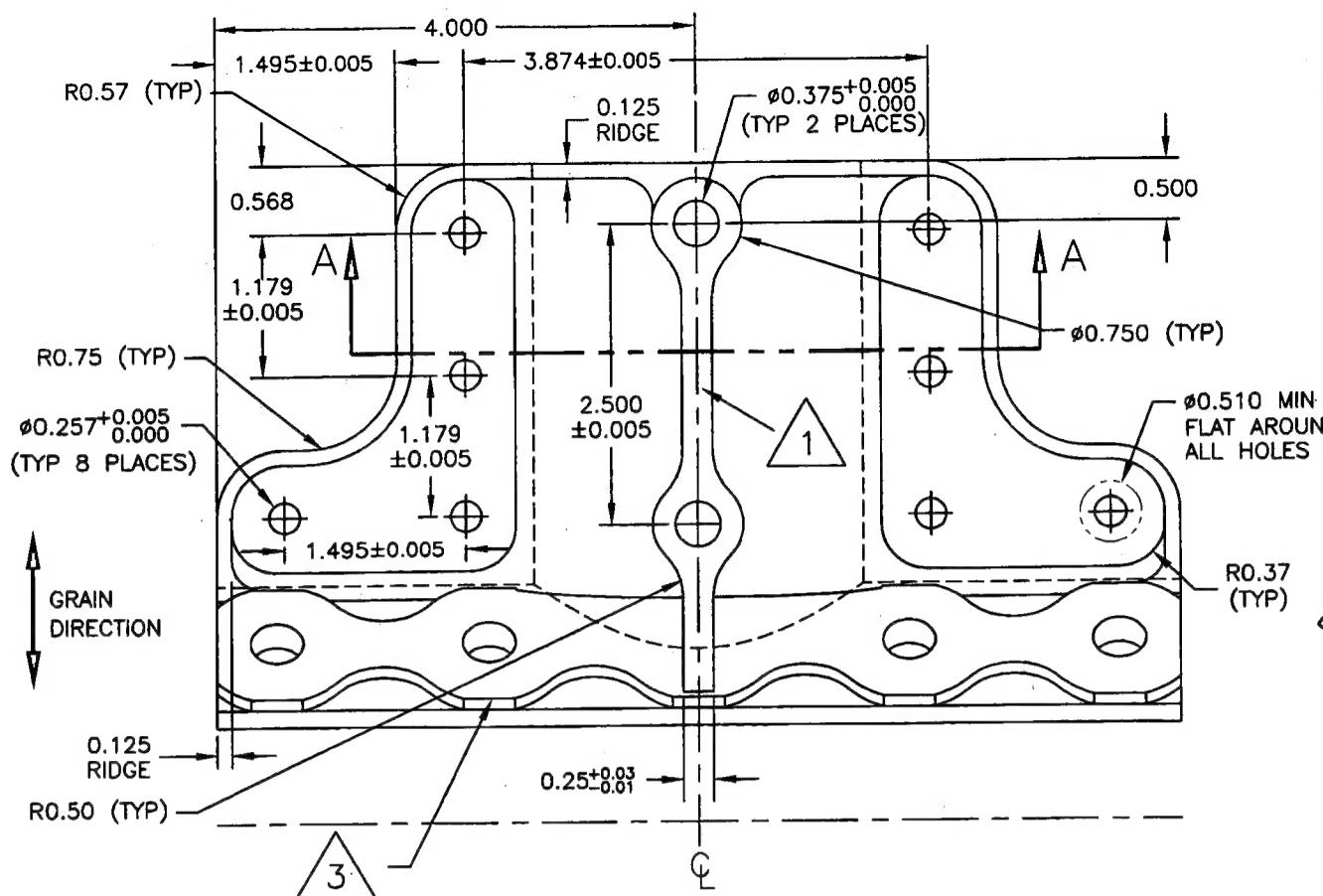
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	6	7	8		
A	0.438	0.443		.441	.441	.442	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.002	8.001	8.001	8.002		
F	0.490	0.510		.505	.500	.505	.505		
G	0.257	0.262		0.259	0.259	0.259	0.258		
H	0.375	0.380		0.378	0.378	0.378	0.375		
I	0.490	0.510		.505	.501	.505	.505		
J	1.174	1.184		1.179	1.177	1.179	1.179		
K	0.558	0.578		.568	.568	.568	.567		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.499	1.499	1.500	1.495		
N	2.495	2.505		2.498	2.499	2.500	2.500		
O	3.869	3.879		3.873	3.874	3.874	3.874		
P	0.115	0.135		0.124	0.125	0.122	0.122		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.236	0.257	0.258	0.258		
S	0.115	0.135		.122	.125	.125	.115		
T	0.178	0.198		0.188	0.188	.188	.188		
U	2.940	2.980		2.938	2.939	2.960	2.960		
V	0.230	0.250		.243	.240	.240	.240		
W	0.115	0.135		.125	.125	.125	.120		
X	0.307	0.312		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.362	.362	.362	.358		
AA	0.470	0.530		0.500	0.500	.500	.500		
AB	0.615	0.635		.625	.625	.625	.620		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.385	1.385	1.381	1.389		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		0.260	0.260	.260	.260		
AH	0.240	0.260		.250	.250	.250	.249		
AI	2.000	2.020		2.002	2.001	2.001	2.001		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	DT	1/15	Audited by:	JL
Date:	08/05/11	06/05/14	Date:	08/05/11

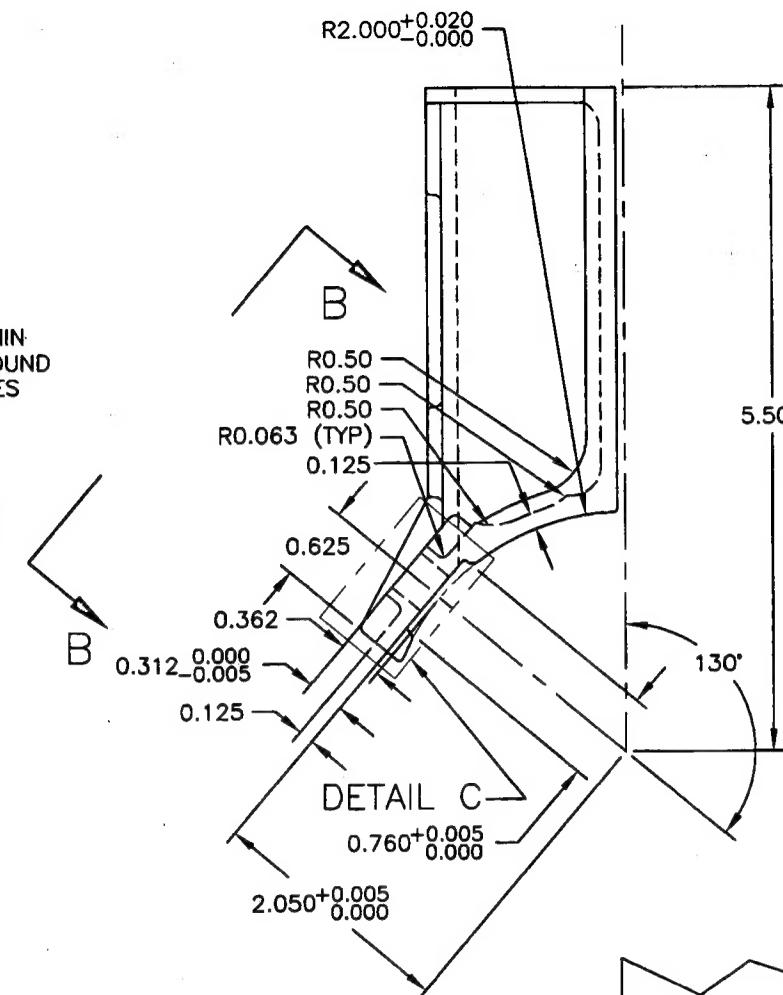
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	2/11/14

RELEASED

05.12.06



SECTION A-A

DETAIL C
SCALE 2:10.438^{+0.005}_{-0.000}

(TYP 4 PLACES)

0.500

0.060

0.025

(TYP)

4

(TYP)

0.025

(TYP)

0.025

(TYP)

0.025

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RETURN TO

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 3892

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

DESIGN DS	DRAWN BY PH	DART	DART AEROSPACE LTD. HAWKSLEY, ONTARIO, CANADA
CHECKED <input checked="" type="checkbox"/>	APPROVED <input checked="" type="checkbox"/>	DRAWING NO.	REV. E
		D2572	SHEET 1 OF 1
DATE 05.07.13	TITLE INNER FWD SADDLE	SCALE 2:3	

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